

**\*83003\***

Thursday, April 12, 2012 11:16:35 AM

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 4/12/2012      **Start Qty:** 1.00      **\*1\***

**Cust Item ID:**

**Required Date:** 4/24/2012      **Req'd Qty:** 1.00      **\* 1 \***

**Customer:**

**Reference:**

Approvals: Process Plan: [Signature] Date: 12-04-12 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

OC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

### Operation Description

### Set Up/ Run Hours

### Tool ID

**Tool #**

**Plan  
Code**

**Accept  
Qty**

Reject  
QtyReject  
Number

**Insp.  
Stamp**

**Draw Nbr**

Revision Nbr

D3021

Rev A

100

0.00

\*100\*

## Large Fab

Large Fab

## Memo

0.00

## Large Fab

1-Cut tube as per Dwg D3021

2-Drill tube as per Dwg D3021 using D8622

3-Deburr

4-Weld as per Dwg D3021 QSI004

A/R 4130 Rod Batch: *m 118875*

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

**\*110\***

QC

## Memo

0.00

## Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 83003

\*83003\*

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Thursday, April 12, 2012 11:16:35 AM

Item ID: D3021-041 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Tube Assembly  
 Start Date: 4/12/2012 Start Qty: 1.00 \*1\* Cust Item ID:  
 Required Date: 4/24/2012 Req'd Qty: 1.00 \*1\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
*120*		0.00							
QC	Memo								
Quality Control									
130	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
*130*		0.00							
Powdercoat	Memo								
Powder Coating	START TIME: 3:00								
	OVEN TEMPERATURE: 320°F								
	FINISH TIME: 3:30								
140	QC3- Inspect Part Finish	0.00							
*140*		0.00							
QC	Memo								
Quality Control									

m121279

1X ✓ M/L 12/06/20  
 1/2 ✓ 12/06/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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mw 12/06/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, April 12, 2012 11:16:39 AM

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Work Order ID: 83003

\*83003\*

Parent Item: D3021-041

\*D3021-041\*

Parent Item Name: Tube Assembly

Start Date: 4/12/2012

Required Date: 4/24/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP 01.10.23 New Issue SM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3017-11		Manufactured	No			100	Each	54.0000	2	2			

\*D3017-11\*

cap

\*\*

Q 12-6-20

Location

Loc Qty

Loc Code

WA021

54

76851

54

M4130NT0.750W.049

Purchased

No

100

f

125.6700

2.0833

2.192947

\*M4130NT0 750W 049\*

4130 RD Tube .750 x.049W

\*\*

Q 12-6-20

Location

Loc Qty

Loc Code

MAT033

125.67

118772

13.04

120350

67.8

121025

44.83

2.19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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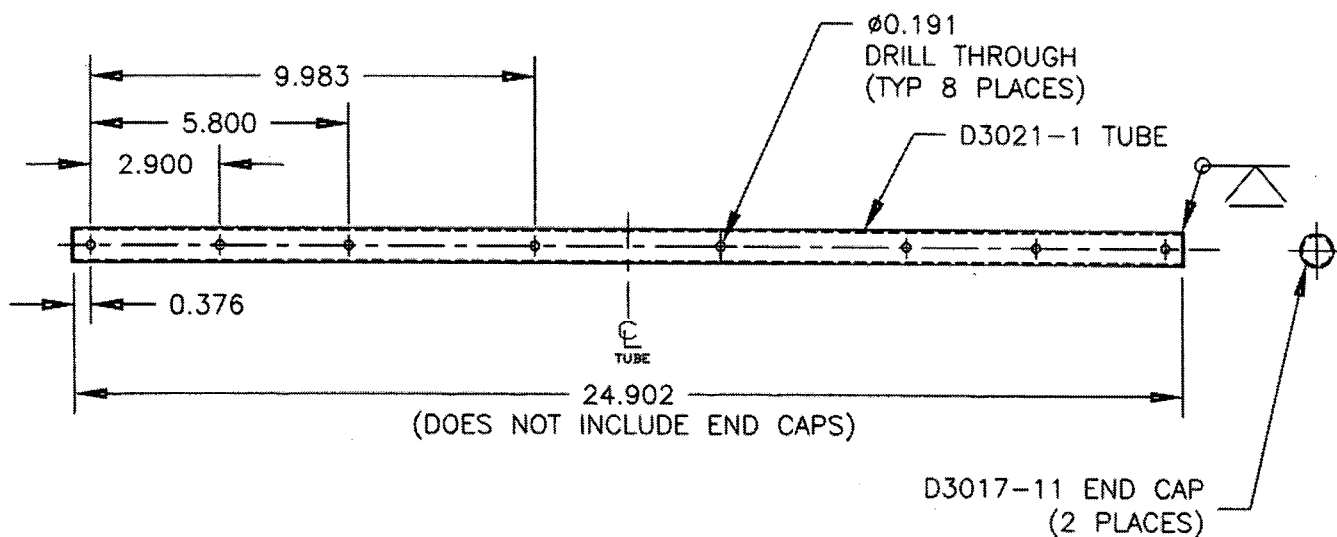




DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3021	REV. A SHEET 1 OF 1
DATE 01.05.18		TITLE TUBE ASSEMBLY	SCALE 1:4
A	01.05.18	NEW ISSUE	

SHOP COPY  
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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 83003

*PL1204-12*



D3021-041 TUBE ASSEMBLY  
(D3021-1 TUBE)

**NOTES:**

- 1) PART IS SYMMETRIC ABOUT CENTERLINE
- 2) MATERIAL: AISI 4130 TUBE,  $\phi 0.75$  DIA x 0.049 WALL (M4130N-T0750W049)
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

**RELEASED**  
01.05.30

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